

Work Order ID 60325

July 5, 2010 10:37:22 AM



Page 1

Item ID: D2232-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Hinge

Start Date: 7/05/10 Start Qty: 6.00



Cust Item ID:

Required Date: 7/09/10 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: C2 Date: 10/7/05 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2232	Rev C								
100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2232 <input type="checkbox"/> Dwg Rev: <u>C</u> <input type="checkbox"/> Prog Rev: <u>C</u> <input type="checkbox"/> 2- Deburr if necessary								
110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									
120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

ml 10 07 07 (6)

ml 10 07 07 (6)

8/6/10

(6)

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Deburr								
140 	Identify as per dwg & Stock Location: <u>WA</u>	0.00							
Packaging	Memo	0.00							
Packaging									
150 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

SAD

10-07-07



10-07-08

MF
10-7-7

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 60325



Parent Item: D2232-3



Parent Item Name: Basket Hinge

Start Date: 7/05/10

Required Date: 7/09/10

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP B 01.06.07 Now laser cut EC
IPP Rev:C Now on Waterjet 06-10-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	125.4659	0.0694	0.438316			



304/316 0.125 Sheet

Location

Loc Qty

Loc Code

MAT

125.4659

114488

1.9659

114799

123.5

MM 10-07-07

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

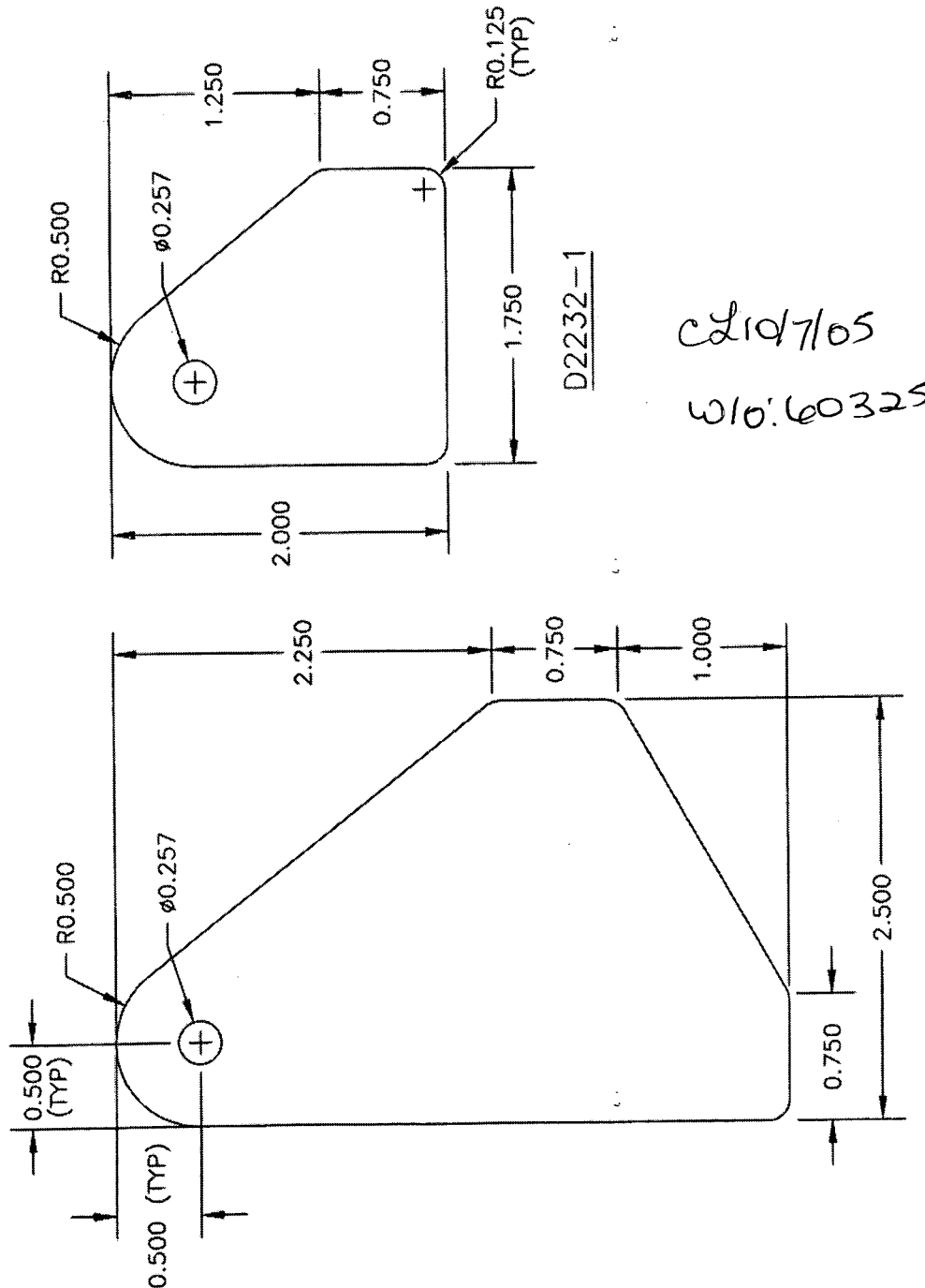
NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>W</i>	APPROVED <i>KE</i>	DRAWING NO. D2232	REV. C SHEET 1 OF 2
DATE 98.04.28		TITLE BASKET HINGE	SCALE 1:1
A	94.05.12	NEW ISSUE	
B	96.01.02	ADDED -5 AND -7	
C	98.04.28	0.125 THICK WAS 0.063	

RELEASED
98.05.05 KE



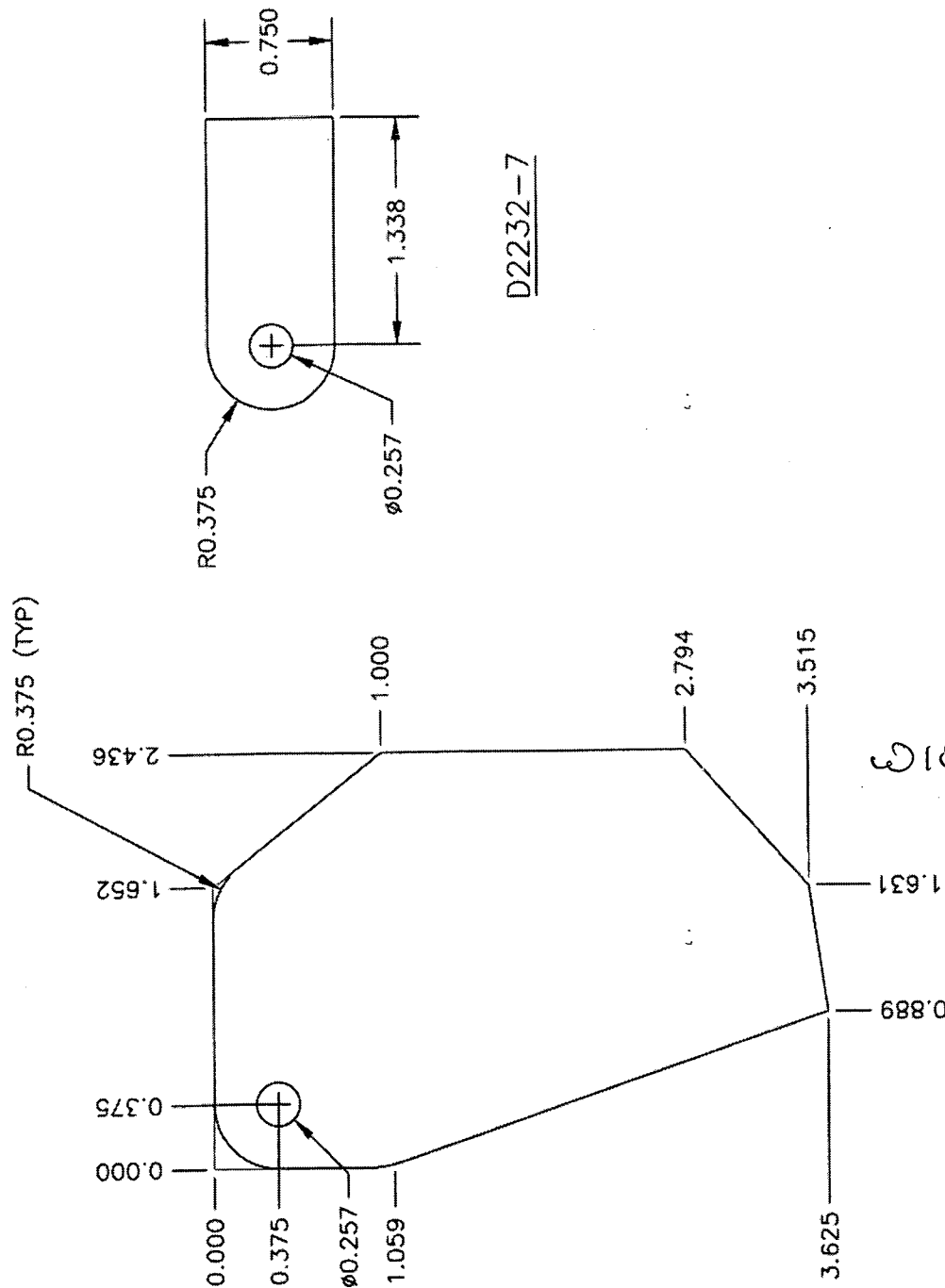
CLD/7/05
W10.60325

MATERIAL: AISI 304/316 SS 0.125 THICK



DESIGN <i>[Signature]</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2232	REV. C SHEET 2 OF 2
DATE 98.04.28		TITLE BASKET HINGE	SCALE 1:1

RELEASED
98.05.05 KE



D2232-7

D2232-5

MATERIAL: AISI 304/316 SS 0.125 THICK

1 000
0 320
9 200
9 200
0 320
0 0921

DWELL